

Work Order ID 72749

Friday, August 12, 2011 9:02:58 AM



Page 1

Item ID: DSI 9189-011

Accept



Setup Start



Revision ID:

Item Name: Latch Modification, 350

Stop



Start Date: 8/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Handwritten signature]

Date:

11-08-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9189

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI 9189-011 CHG001

Subslog

[Handwritten signature] CL 11-9-1

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Subslog

[Handwritten mark]

120

Identify as per dwg & Stock Location: *20*

0.00



Packaging

Memo

0.00

Packaging

Rev A

11/9/11 *SD* *D*

Work Order ID 72749

Friday, August 12, 2011 9:02:58 AM



Page 2

Item ID: DSI 9189-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Modification, 350

Start Date: 8/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/16 [Signature]
JMF
11-09-01

Friday, August 12, 2011 9:03:02 AM






[illegible]

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Required Date: 8/16/2011

Required Qty: 2.00

Comments: IPP A00.05.30 New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 	NAS1149D0363J	Purchased	No			110	Each	0.0000	2	4			
Washer D2463-0025 		Manufactured	No			110	Each	0.0000	2	4			
Neoprene Seal D2585 		Manufactured	No			110	Each	54.0000	2	4			
Mounting Channel													
					<u>Location</u>					<u>Loc Qty</u>			
					ST017					54			
					70814					54			
D2586 		Manufactured	No			110	Each	74.0000	2	4			
Door Latch													
					<u>Location</u>					<u>Loc Qty</u>			
					ST204					74			
					64774					24			
					70557					50			
D2589 		Manufactured	No			110	Each	83.0000	1	2			
Keys, Key Chain, 350 Hinge													
					<u>Location</u>					<u>Loc Qty</u>			
					ST018					83			
					58194					83			

Picklist Print

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Work Order ID: 72749

Parent Item: DSI 9189-011

Parent Item Name: Latch Modification, 350

Start Date: 8/12/2011

Required Date: 8/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2621
Latch Plate, 350 Spacepod

Manufactured No

110 Each

21.0000

2 4



SP SP 11-09-01

Location

Loc Qty

Loc Code

ST019

21

56526

21

D2980
Latch Plate

Manufactured No

110 Each

20.0000

2 4



SP SP 11-09-01

Location

Loc Qty

Loc Code

MEZZ

20

12565

7

12691

13

MS21042L3
Nut

Purchased No

110 Each

1,925.000

2 4



SP SP 11-09-01

Location

Loc Qty

Loc Code

ST300

1925

117441

272

117601

400

117885

253

118451

1000

MS27039-1-18
Screw

Purchased No

110 Each

80.0000

2 4



SP SP 11-09-01

Location

Loc Qty

Loc Code

ST292

80

115589

80

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Shop Packet Print

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DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9189	REV. A SHEET 1 OF 3
DATE 00.05.23		TITLE AFT AND SIDE DOOR LATCH MOD.	SCALE NTS
A	00.05.23	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWINGS: D350-588 REV. A OR EARLIER
D350-589 REV. A OR EARLIER

REF. CANADIAN STC: SH92-41
US FAA STC: SH1012NE

REFERENCE ONLY

INTRODUCTION

THE PURPOSE OF THE DSI 9189-011 KIT IS TO PROVIDE THE HARDWARE TO REPLACE THE D2443 LATCHES (REF. HARTWELL PART NUMBERS H605S190A496 OR H2818-3S125A OR H605K3240) WITH D2586 LATCHES.

PART LIST

Qty -011	Part Number	Description
X	DSI 9189-011	LATCH MODIFICATION KIT
2	D2463-0025	1/2" FOAM SEAL
2	D2585	MOUNTING CHANNEL
2	D2586	LATCH
1	D2589	KEYS, KEY CHAIN
2	D2621	LATCH PLATE
2	D2980	LATCH PLATE
2	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9189	REV. A SHEET 2 OF 3
DATE 00.05.23		TITLE AFT AND SIDE DOOR LATCH MOD.	SCALE NTS

PROCEDURE:
AT EACH LATCH LOCATION

REFERENCE ONLY

1. REMOVE EXISTING D2443 LATCH AND D2383 LATCH BRACKET COVER FROM THE DOOR. DO NOT REMOVE D2382 LATCH BRACKET.
2. REMOVE 2.5" (MAX) OF SEAL FROM EDGE OF THE DOOR PER FIGURE 1.
3. DRAW A LINE CONNECTING THE CENTRES OF THE TWO LARGE HOLES FOR THE EXISTING LATCHES.
4. LINE UP THE INSIDE EDGE OF THE D2980 LATCH PLATE WITH THE EDGE OF LARGER LATCH HOLE AS SHOWN IN FIGURE 1. MAKE SURE THE D2980 LATCH PLATE IS CENTERED ON THE LINE CREATED AT STEP 3.
5. USING THE D2980 LATCH PLATE AS A TEMPLATE, MARK THE CUTOUT PROFILE FOR THE LATCH.
6. CUT A HOLE IN THE DOOR PER THE PROFILE CREATED AT STEP 5. TRIM TO FIT D2586 LATCH.
7. CLEAN THE INSIDE OF D2382 AND OUTSIDE OF THE DOOR IN THE VICINITY OF THE D2621 AND D2980 LATCH PLATES WITH ACETONE.
8. INSTALL D2621 LATCH PLATE OUTSIDE AND D2980 LATCH PLATE INSIDE OF THE DOOR AS SHOWN IN SECTION A-A USING 5 MIN. EPOXY OR PRC. ENSURE THAT THE LATCH PLATES LINE UP WITH THE RECTANGULAR CUTOUT FOR THE D2586 LATCHES. CLAMP LATCH PLATES IN PLACE. FILL THE VOID BETWEEN THE D2621 AND D2980 LATCH PLATES AS SHOWN IN FIGURE 1 WITH 5 MIN. EPOXY OR PRC. WIPE AWAY EXCESS EPOXY OR PRC FROM ALL AROUND THE LATCH PLATE INSTALLATION. ALLOW AT LEAST 15 MIN. BEFORE REMOVING CLAMPS AND PROCEEDING TO THE NEXT STEP.
9. INSTALL REPLACEMENT D2463-0025 NEOPRENE SEAL OVER THE D2980 LATCH PLATE.
10. INSTALL D2586 LATCH AND D2585 MOUNTING CHANNEL PER FIGURE 2.

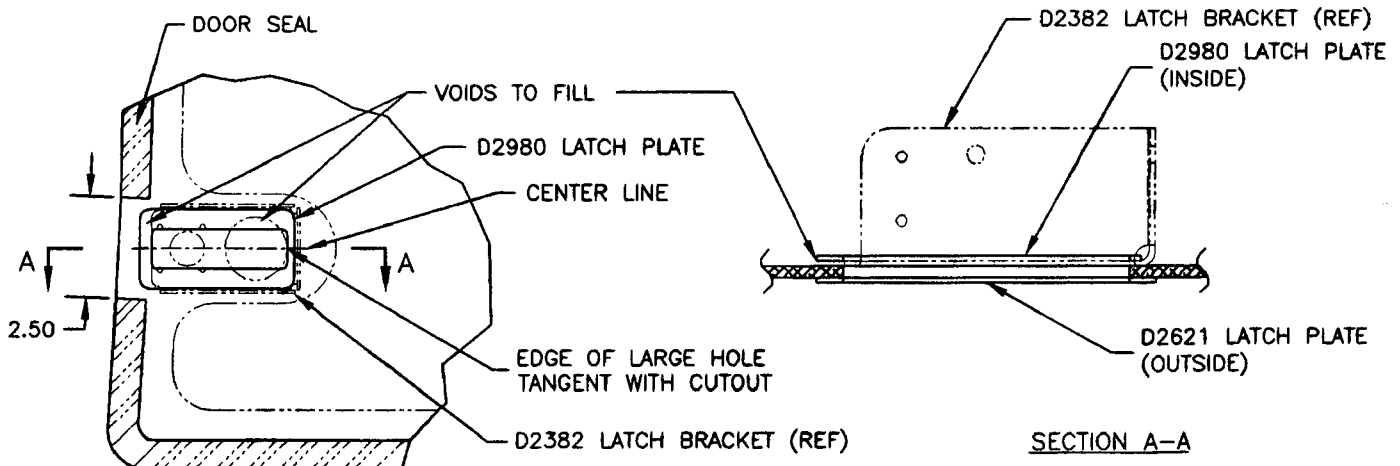


FIGURE 1: TYPICAL DOOR CUTOUT

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9189	REV. A SHEET 3 OF 3
DATE 00.05.23	TITLE AFT AND SIDE DOOR LATCH MOD.		SCALE NTS

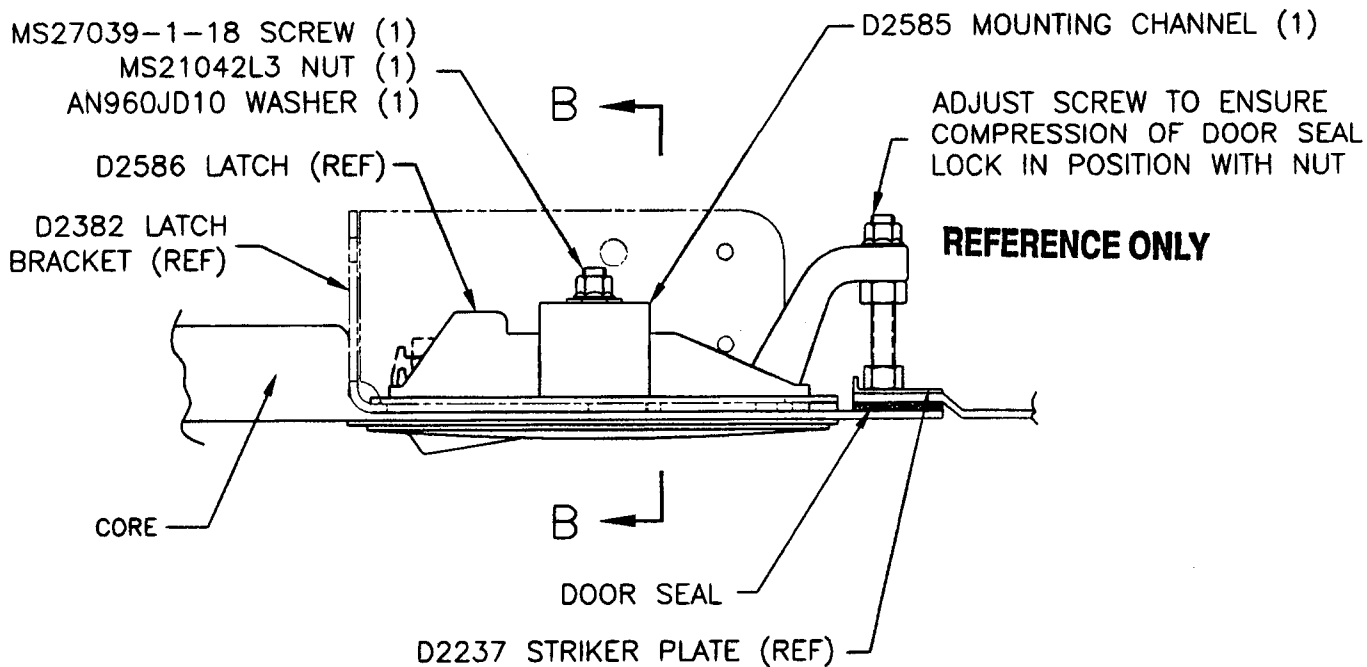
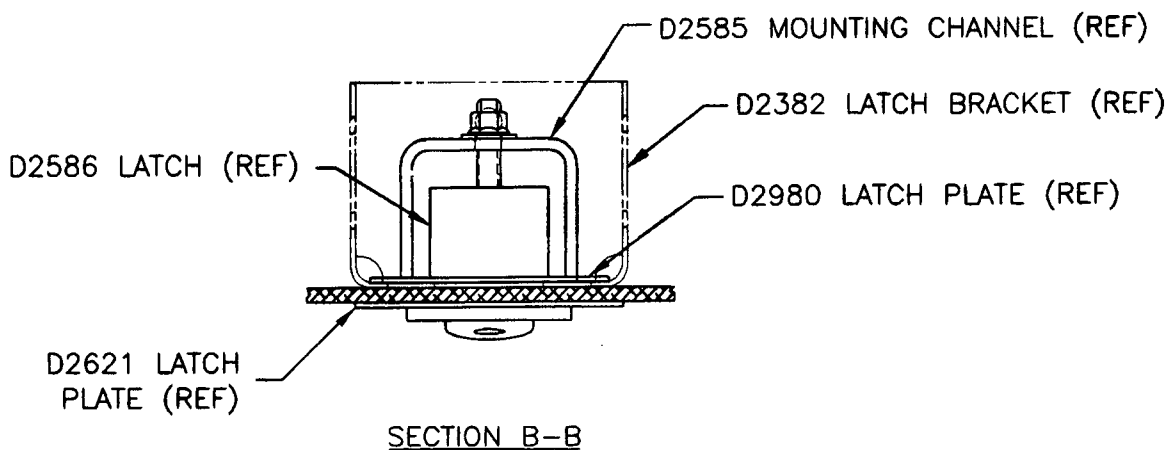


FIGURE 2: TYPICAL LATCH INSTALLATION



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